

**Work Order ID 78990****\*78990\***

Page 1

Item ID: D3401-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Tow Cap Assembly

Start Date: 18/01/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 01/02/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/01/18 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3401

Rev B

100

0.00

**\*100\***

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blanks 4.20" Long

SL 12/2/14

11

φ

110

0.00

**\*110\***

DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

Turn as per Folio FA532 &amp; Dwg D3401

Folio Rev: N/ADwg Rev: 3

Deburr

SL 12/2/14

11

φ

120

0.00

**\*120\***

QC2- Inspect parts off machine FAI/FAIB~

QC

Memo

0.00

Quality Control

SL 12/2/14

11

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**Accept**

Setup Start \*NS1\*

Stop \*NS2\*

**Cust Item ID:**

**\*10\***

**\*10\***

**Customer:**

**Reference:**

Run Start \*NR1\*

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

## Operation Description

### Set Up/ Run Hours

Tool ID

Tool #

**Plan  
Code**

**Accept  
Qty**

Reject  
Qty

## Reject Number

**Insp.  
Stamp**

150

0.00

**\*150\***

## Small Fab

0.00

### Small Fab

## Memo

## Small Fab

Drill and c'sink using DT8782 as per Dwg D3401

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

## Memo

0.00

## Quality Control

170

Chemical Conversion Coat per QSI005 4.1

0.00

**\*170\***

HandFinish

## Memo

0.00

## Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 78990

\*78990\*

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Item ID: D3401-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Tow Cap Assembly  
 Start Date: 18/01/2012 Start Qty: 10.00 \*10\* Cust Item ID:  
 Required Date: 01/02/2012 Req'd Qty: 10.00 \*10\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
*180*									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11~30								
	OVEN TEMPERATURE: 320°F								
	FINISH TIME: 12~00								
190	QC3- Inspect Part Finish	0.00							
*190*									
QC	Memo	0.00							
Quality Control									
195	Assemble as per dwg	0.00							
*195*									
HandFinish	Memo	0.00							
Hand Finishing									

10x d m 12/03/02

10x d m 12/03/06

10x d m 12/03/06

m 120222

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



# Work Order ID 78990

**\*78990\***

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January-18-12 8:37:28 AM

Item ID: D3401-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Tow Cap Assembly  
 Start Date: 18/01/2012 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 01/02/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 <b>*200*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				<u>11</u>	<u>12</u>	<u>03</u>	<u>06</u> (11)
210 <b>*210*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-2</u>  Memo	0.00  0.00				<u>11</u>	<u>4</u>	<u>12</u>	<u>03</u> <u>10</u> <u>6</u>
220 <b>*220*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00				<u>12/3/7</u>			<u>11</u>

12-03-4  
(11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 78990

\*78990\*

Parent Item: D3401-041

\*D3401-041\*

Parent Item Name: Tow Cap Assembly

Start Date: 18/01/2012

Required Date: 01/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A05.09.01New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1330C3KB116		Purchased	No			100	Each	638.0000	4	40' 44			
*NAS1330C3KB116*										**	22 12/2/10		
Insert													

Location

Loc Qty

Loc Code

ST276

638

102606

200

103337

438

444

M6061T6R3.500

Purchased

No

200

f

10.8970

0.35

3.684211

\*M6061T6R3 500\*

6061 RD bar 3.50

\*\*

SA 12/2/14

Location

Loc Qty

Loc Code

MAT005

10.527

116808

0.027

119231

10.5

MAT036

0.37

110993

0.37

444

\* No mat in system - could not pull

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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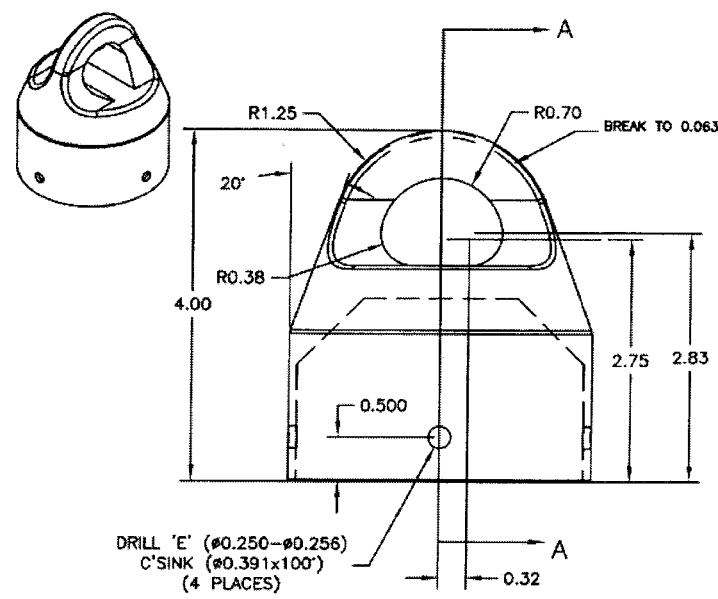


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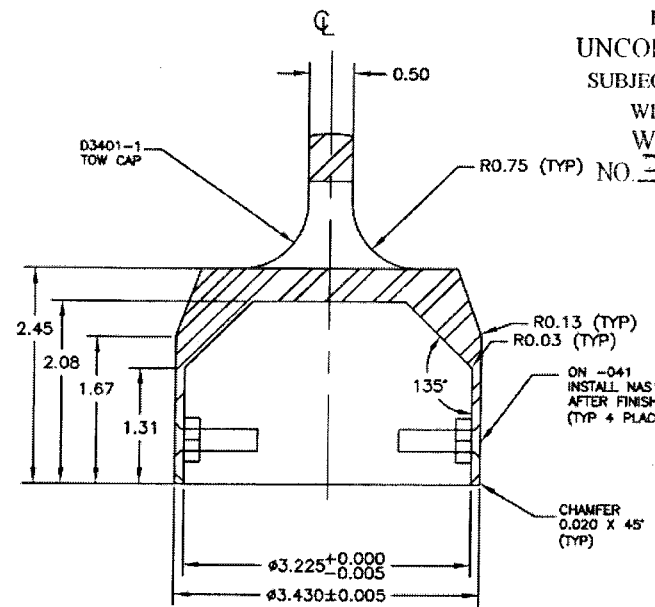
ENGINEERING  
UNCONTROLLED  
SUBJECT TO ANY  
WITHOUT  
WORK ORDER  
NO. 78990

12/01/18

**DART**



**D3401-1 TOW CAP**



**D3401-1/-041 TOW CAP**

**D3401-1 TOW CAP**

- 1) MATERIAL: MAKE FROM ALUMINUM 6061-T6 Ø3.500 ROUND BAR PER QQ-A-225/8 OR AMS-QQ-A-200/8 (REF. DART SPEC M6061T6R3.5000)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D3401-041 TOW CAP**

- 1) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

**D3401-041 TOW CAP PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
1	D3401-1	TOW CAP
4	NAS1330C3KB116	INSERT

DESIGN	DRAWN BY	DATE	TITLE	SCALE
PH	PH	05.06.09	TOW CAP	1:2
CHECKED	APPROVED	05.02.24	NEW ISSUE	
		05.06.09	CHAMFER INSIDE, REMOVE RADIUS	

RELEASED  
05-08-09

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DART AEROSPACE USA, INC.  
PORT HADLOCK, WA

REV. B  
SHEET 1 OF 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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